

Date: Tuesday, 23/12/2008 1:22:26 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP LEG
<b>Job Number</b> : 44293A	
<b>Estimate Number</b> : 10353	
<b>P.O. Number</b> :	<b>Part Number</b> : D2278
<b>This Issue</b> : 23/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2278 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 40087A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/01/2009 <b>Qty:</b> 32 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM Est Rev C New flat pattern 08.01.11 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S080	6061-T6 .080 Sheet
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**Comment:** Qty.: 1.0306 sf(s)/Unit Total : 32.9784 sf(s)  
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick  
 (M6061T6S.080)  
 Identify as D2278  
 Batch: 109184 IB 8-12-30

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2278  
 Dwg Rev: F  
 Prog Rev: F

IB 8-12-30

2-Deburr if necessary

IB 8-12-30

34

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-12-30

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08-12-30

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/12/2008 1:22:26 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 44293A

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 9-01-06



1/32

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 09/01/07

34

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: G-A

EP 09/01/07

34

8.0

QC21

FINAL INSPECTION/W/O RELEASE



34

Comment: FINAL INSPECTION/W/O RELEASE

AD 09/07/07

Job Completion



U 09.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

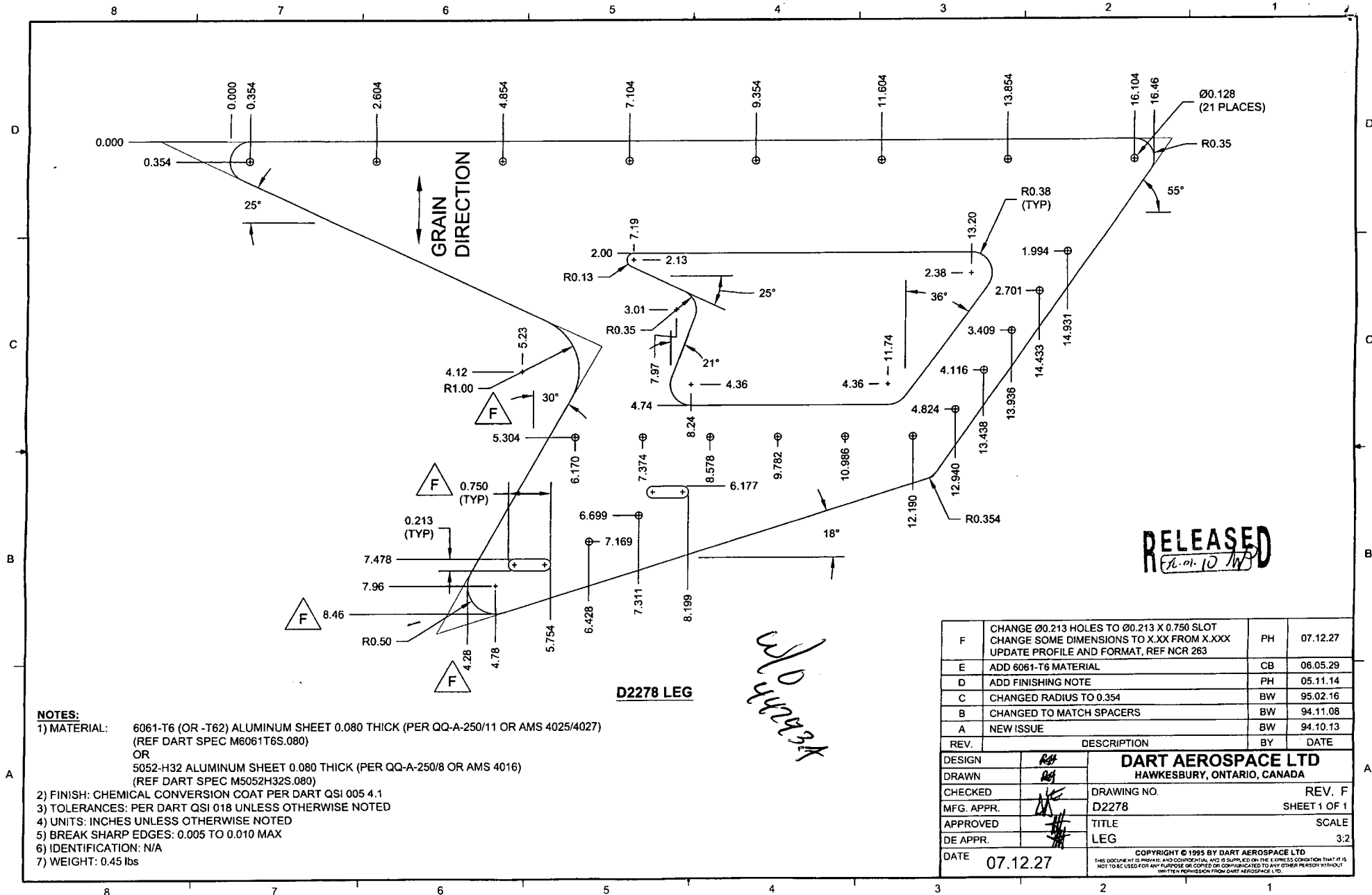
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

064



**NOTES:**

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.080) OR 5052-H32 ALUMINUM SHEET 0.080 THICK (PER QQ-A-250/8 OR AMS 4016) (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

**D2278 LEG**

*Handwritten note:* 0.00434

**RELEASED**  
A-01.10.14

F	CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 263	PH	07.12.27
E	ADD 6061-T6 MATERIAL	CB	06.05.29
D	ADD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.08
A	NEW ISSUE	BW	94.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RA</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RA</i>		
CHECKED	<i>KE</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>KE</i>	D2278	SHEET 1 OF 1
APPROVED	<i>KE</i>	TITLE	SCALE
DE APPR.	<i>KE</i>	LEG	3:2
DATE	07.12.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries







